

Work Order ID 84624

84624

Page 1

May-17-12 11:47:06 AM

Item ID: D044-715-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3243 | Rev A | | | | | | | | |
| IIN-D044-715 | Rev A | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPPD044-715-011 | | CHG003 | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

MLJ 12/05/13

JB

50

3

12/05/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 84624

84624

Page 2

May-17-12 11:47:06 AM

Item ID: D044-715-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D044-715-011

Location: 42

140

0.00

140

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

(3)

30

12/07/13 (3)

MLJ 12/07/13

MLJ 12/07/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

May-17-12 11:47:10 AM

Page 1

Work Order ID: 84624

84624

Parent Item: D044-715-011

D044-715-011

Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A04.02.18New issueKJ/JLM

IPP Rev:B 06-04-28 Manufactured on Water Jet JLM

IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D

11.05.04 remove FE-032-EF DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3243-041

Manufactured

No

110

Each

3.0000

D3243-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST227

3

76859

3

D1048

Manufactured

No

110

Each

58.0000

D1048

Saddle

**

Location

Loc Qty

Loc Code

GA

58

71872

2

76951

56

D1049

Manufactured

No

110

Each

20.0000

D1049

Saddle

**

Location

Loc Qty

Loc Code

GA

20

79033

20

D2010-104

Manufactured

No

110

Each

4.0000

D2010-104

Mirror Arm 369/500

**

Location

Loc Qty

Loc Code

ST220

4

74717

4

**

**

**

**

B862864

76859 (2x)
6

2x 71872
4x 76951
6

79033
3

74717

12/03/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

May-17-12 11:47:10 AM

Page 2

Work Order ID: 84624

84624

Parent Item: D044-715-011

D044-715-011

Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

D2011-101

Manufactured No

110 Each

36.0000



3

D2011-101

6" Mirror

**

Location

Loc Qty

Loc Code

ST226

36

79943

36

AN3-4A

Purchased

No

110 Each

678.0000



12

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

678

102832

88

104291

4

104625

208

117317

98

120308

80

120770

200

AN526C1032R10

Purchased

No

110 Each

203.0000



12

AN526C1032R10

Screw

**

Location

Loc Qty

Loc Code

FP002

71

108062

71

ST348

132

110049

32

114494

100

May-17-12 11:47:10 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

May-17-12 11:47:10 AM

Work Order ID: 84624

84624

Parent Item: D044-715-011

D044-715-011

Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

ALS4-1032-130

Purchased

No

110

Each

3,287.000



12

**

JB



ALS4-1032-130

Insert

S.B.

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

174

120807

36

120837

138

ST282

2908

121269

2908

AN960JD10L

NAS1149D0332J

Purchased

No

110

Each

0.0000



12

**

121269

121011

JB

12/05/29

AN960JD10L

Washer

S.B.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

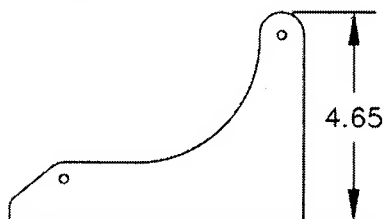
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3243 | REV. A SHEET 1 OF 1 |
| DATE 04.01.09 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.09 | NEW ISSUE | |



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84624 MCT
12/05/17

8.581
8.206
7.706

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

GRAIN
DIRECTION

1.375

5.273

4.214
R0.25 (TYP)
3.339

3.714

R0.38
(TYP)

R2.75
(TYP)

5.494

D3243-1
FLAT PATTERN

R0.50
(TYP)

0.500
0.000
0.000
0.000

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

32.2 CARGO MIRROR REMOVAL

- 32.2.1 Remove the AN3 bolts securing the D3243-041 Bracket to the skidtube and remove the Cargo Mirror.
- 32.2.2 Reinstall the AN3-4A bolts in the inserts. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing.

32.3 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---|-------------------|-------------------|-------------------------|-------------------|-------------------------|
| | | Arm | Moment | Arm | Moment |
| D044-715-011 Cargo Mirror Installation | 1.3 lb 0.59 kg | 41.7 in 1.06 m | 54.2 lb-kp 0.63 m-kp | 32.0 in 0.81 m | 41.6 in-lb 0.48 m-kp |

32.4 PARTS LIST

| Qty | Part Number | Description |
|-----|---------------|---|
| X | D044-715-011 | CARGO MIRROR INSTALLATION |
| 2 | D1048 | Clamp |
| 2 | D1049 | Saddle |
| 1 | D2010-104 | Arm |
| 1 | D2011-101 | Mirror |
| 1 | *D3014-1 | Locknut |
| 1 | D3243-041 | Bracket |
| 4 | ALS7-1032-130 | Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130) |
| 4 | AN3-4A | Bolt |
| 4 | AN526C1032R10 | Screw (or AN526-1032R10) |
| 4 | AN960JD10L | Washers |
| 1 | *AN960JD416L | Washer |

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

TC Accepted

MAR 31 2004

• COPYRIGHT © 2004 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

32-00-00